

Work Order ID 137485***137485***

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October 02, 2015 2:24:24 PM

Item ID: D2478 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access Handle
Start Date: 10/2/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 10/30/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: SM **Req'd 15100** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2478	Rev A								

110 NC BRAKE 0.00
110
Large Fab
Large Fab
Memo 0.08
1- CUT TUBE AT 31.00"
2- MARK TUBE AT 7.95", 15.5", 23.05"
(7.95" TO 23.05" SHOULD GIVE YOU 15.1" IN BETWEEN)
THESE LINE WILL BECOME YOUR BEND LINES AND 15.5" IS YOUR
CENTER LINE.
3- BEND USING RIGID BENDER 3.75" RAD. AND TRIM TO SIZE USING
DT2478
10 FF OCT 06 2015

120 QC5- Inspect part completeness to step on W/O 0.00
120
QC Memo 0.00
Quality Control
10 DAS 38 9-89
OCT 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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130	Identify as per dwg & Stock Location: <u>W/A001</u>	0.00							
130						<u>10</u>	<u>02</u>	<u>15-10-7</u>	
Packaging	Memo	0.00							
Packaging	LOCATION WA002								
140	QC21- Final Inspection - Work Order Release	0.00							
140						<u>ML5</u>		<u>OCT 02 2015</u>	
QC	Memo	0.02							
Quality Control									

ML5
OCT 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 137485

137485

Parent Item: D2478

D2478

Parent Item Name: Heli-Access Handle

Start Date: 10/2/2015

Required Date: 10/30/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B99.03.12Updated from hand written IPPDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TR0.750W.049

Purchased

No

100

f

69.1874

3

31.57895

M304TR0 750W 049

FF

OCT 05 2015

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

GA002

65.8662082

M128084

3.4736842

M129363

3.5

M130292

0.51

M132270

31.3059

M132775

8.859604

M133131

18.21702

MAT

3.32121

M132562

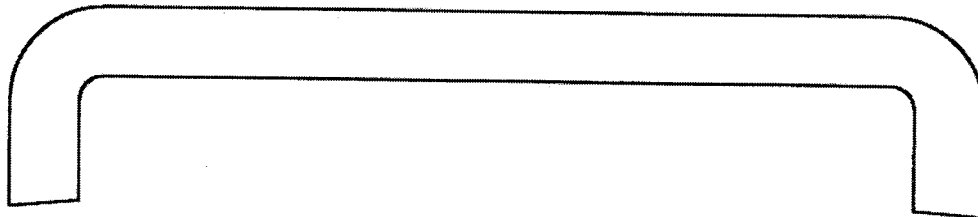
3.32121

9.473685
9.473685
12.63150



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED	APPROVED	D2478	SHEET 1 OF 1
BW	BW	TITLE	SCALE
DATE		HELI-ACCESS HANDLE	1:1
96:05:14			

RELEASED
96/10/02 DS



CUT PER TEMPLATE DT 2478 CT
BEND PER TEMPLATE DT 2478 BT
TRIM PER TEMPLATE DT 2480 CJ

MATERIAL: 304/316 SS 0.75 OD 0.049 WALL

20151002
SH 137-185